



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No. CNC/QA/FM/02

Rev. No. 01

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		12905	40/60
2	Machined By		V.T.L. n/c Shop	Drg No. 1.2.0 = 584
3	Pallet Die No.		12981 (6.0) n/c	Rev = 01
4	Die Category	Drg. No.	Turner	
5	Out Side Diameter	Drg. No.	780 n/c	Step OD = 799 n/c
6	Inside Diameter	Drg. No.	660.14 n/c	Tappet = 4"
7	Width of Pellet Die	Drg. No.	324 n/c	Step length = 25.5 n/c
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 10 n/c	Under cut = 9 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		785 n/c	[Tapping n/c of holes = 12 Both Side]
13	Tapping Hole Diameter		M20 = Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 30.4 n/c	Tapping Depth = 38.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 4/10/24

1	As per programme no.			[2 Slot 38.1 mm width 2 mm Deep Both Side]
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked	ok	
4	Defective Holes (If Any)		No	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Count as 260

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	6.5 n/c	Outside (3-3)		Inner					
3	External Relief Depth		26 n/c		20 n/c					
4	Inspection Done Before Hardening By (Name)			Ravi						
5	Material Sent For Hardening By (Name)			Lark Roxace						
6	Material Sent For Hardening On Date			4	10	24				

Inspected By (Sign) & Date

Ravi 4/10/24

Reviewed by (Engineer-CNC) *Satya 4/10/24*

Manager-QA